

Date: Wednesday, 5/16/2007 1:30:10 PM
 User: Kim Johnston

Process Sheet

24

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L /407 STEP ASSY, RH
 Job Number : 32392A *23*
 Estimate Number : 11703
 P.O. Number : *N/A* Part Number : D2724042
 This Issue : 5/16/2007 S.O. No. : *N/A* Drawing Number : D2724 REVC
 Prsht Rev. : *NC* Project Number : *N/A*
 First Issue : *N/A* Type : LARGE FAB ASSY Drawing Revision : *C*
 Previous Run : 32250A Material : *N/A*
 Due Date : 6/12/2007 Qty: 4 Um: Each
 Written By : *07.05.16*
 Checked & Approved By :
 Comment : Est Rev:E As Per Ecn 766 06-01-06 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Qty Part # Description
 1 D2622-120C Extrusion

Batch: *B31984*

Check Material for any Dents or Defects

FF 07.05.31

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Cut D2724-2 using D2622 extrusion as per Dwg D2724
 Deburr and bevel ends for welding

R.M. 07.05.31

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

206 Step Endplate

Pick:

Qty Part Number Description
 2 D2734 End Cap

Batch: *B29340**RE 07.05.31*

4.0 D34581 PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description
 2 D3458-1 Plate

Batch: *B34073**RE 07.05.31*

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Job Number: 32392A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D34583

PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

2

D3458-3

Plate

332481=6

331074=2

J.E. 07.05.31

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT followed by Jig

DT (One End Only)

A/R AL ROD Batch: M10.2756

M10.3317

Grind end cap welds flush

a.m 07/06/04

(4)

J.E. 07.06.04

J.E. 07.06.04

J.E.

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

RH

07/06/05

(4)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

207-06-05

(4)

RH

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m

07.06.07

J.E.

4

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

207-06-07

(4)

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

J.E. 07.06.11

Form: mncs

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Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 32392A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig

DT

A/R AL ROD Batch: M102756

Grind end plate flush.

FL QA 02.06.12

FL-01-06-11 4
4

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/06/13 (4)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2006.13 (4)
(RH)

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

(4X)

Touch up Alodine

M-L

07/06/16

15.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

PL: 4058 66766157 (2)

-PRIME

-PAINT DELFLEET BLUE (PER QSI005)

-CLEAR DELFLEET

(2)

16.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

2007.03 (2)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2724 and QSI 00 5.4.4

M104732

FL 07/07/04 (2)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 07/07/05 (2)

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Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 32392A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *PP 32392*

EP 07/07/05 (2)
FINAL INSPECTION/W/O RELEASE

20.0

QC21



(2)

Comment: FINAL INSPECTION/W/O RELEASE

Datolas

Job Completion



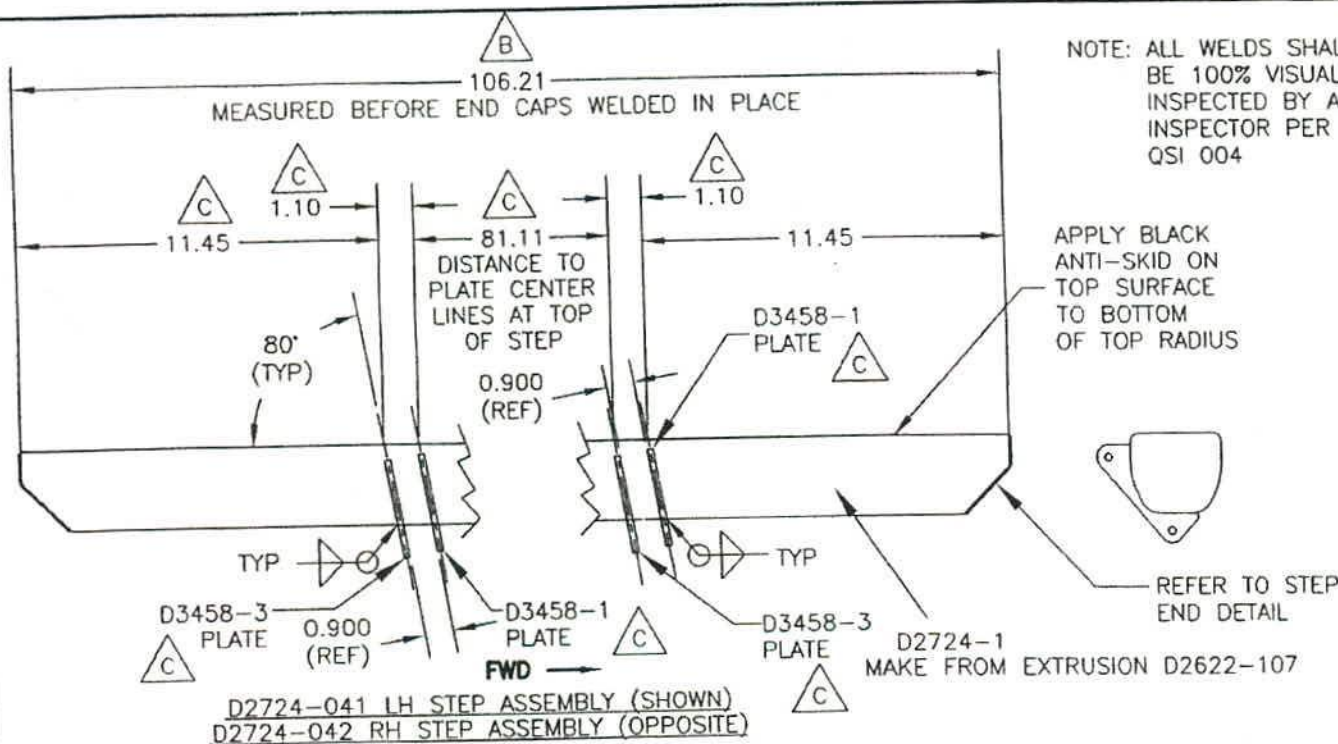
c 207/07/05

DART

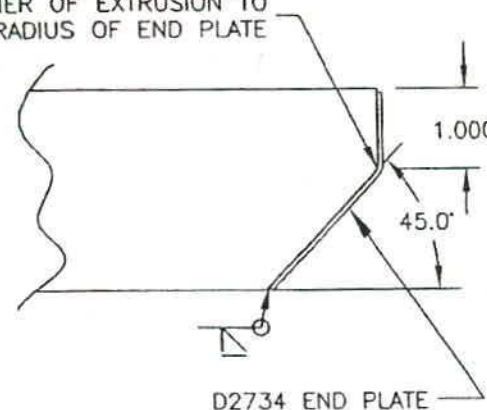
RELEASED

05.11.14

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004



ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE

**D2721-041/-042 STEP ASSEMBLY PARTS LIST**

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO ANENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32392A

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

REV. C

SHEET 1 OF 1

SCALE

NTS

206L/407 STEP ASSEMBLY

NEW ISSUE

UPDATED WELD DETAIL
REVISED TOLERANCES

RE-DESIGN, ADD D3458-1/-3

DESIGN	DRAWN BY	TITLE
KE	PH	D2724
CHECKED	APPROVED	D2724
DATE		
05.09.19		

A	97.12.04	NEW ISSUE
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B	98.10.19	UPDATED WELD DETAIL REVISED TOLERANCES
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C	05.09.19	RE-DESIGN, ADD D3458-1/-3
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